

Work Order ID 58073



April 22, 2010 2:23:32 PM

Item ID: D4049-042

Accept

Setup Start



Stop



Revision ID:

Item Name: Mounting Lug Assembly, RH

Start Date: 4/22/10 Start Qty: 2.00



Required Date: 4/30/10 Req'd Qty: 2.00



Reference:

Run Start

Approvals: Process Plan: YDate: 10-21-22 Tooling: _____ Date: _____

Stop



QC:

Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4049	B

100 Weld per dwg A/R S.S. rod Batch: A103421 0.00

Large Fab

Memo 0.00

Large Fab

1- Weld lug on bracket as per dwg D4049 using DT9583 jig

ER 10-5-4 x2

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC

Memo 0.00

Quality Control

② 10 10-05-04

120 QC5- Inspect part completeness to step on W/O 0.00

QC

Memo 0.00

Quality Control

S. Slobodayx2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58073

Page 2

April 22, 2010 2:23:32 PM

Item ID: D4049-042

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug Assembly, RH

Stop



Start Date: 4/22/10 Start Qty: 2.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

=24/ 10/05/06

X2 0

Powdercoat

Memo

0.00

Powder Coating

POWDER COAT:

Start Time: 2:30 PM

Oven Temperature: 400°C

Finish Time: 3:00 PM

140



QC3- Inspect Part Finish

0.00

2 BL 10-5-6.

QC

Memo

0.00

Quality Control

150



Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging

Ph →
10/05/10 (2)

W/O: 58073

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/05/06	141	Remove wire & weld of back side for hang as P/C (grind off weld)	SD	10/05/07 (2)			SD 10/05/06
	142	Touch up with TIG as per drawing					
	143	Inspect QC5 - SD 10/05/07 (2) -042	SD	10/05/12			SD 10/05/06

Part No: D4049-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 58073

April 22, 2010 2:23:33 PM



Page 3

Item ID: D4049-042

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Setup Start



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Item Name: Mounting Lug Assembly, RH

Stop



Start Date: 4/22/10 Start Qty: 2.00



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Required Date: 4/30/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/12 AJ
MF
10-5-11

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 22, 2010 2:23:31 PM

Page 1

Work Order ID: 58073



Parent Item: D4049-042



Parent Item Name: Mounting Lug Assembly, RH

Start Date: 4/22/10

Required Date: 4/30/10

Comments: IPP RevA: new issue DD 10.01.27 verified by:EC IPP Rev:B as per
dwg revA DD 10.02.18 verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Manufactured	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4049-2 Lug		Manufactured			58076 x 2	100	Each	0.0000	2.0000		EL 10-5-3	
D4049-4 Mounting Plate, RH		Manufactured	No			100	Each	3.0000	2.0000		EL 10-5-3	

Warehouse
Location

Main Warehouse

ENG 1

55371 1

Main Warehouse

WA 2

56201 2

58077 2

W/O:		WORK ORDER CHANGES					
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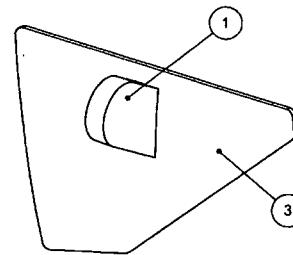
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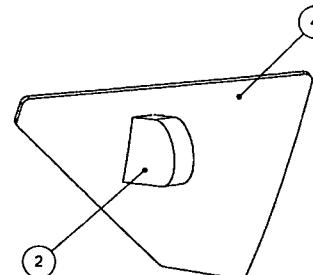
8 7 6 5 4 3 2 1

D

D



D4049-041 MOUNTING LUG ASSY, LH



D4049-042 MOUNTING LUG ASSY, RH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58073

B80422

RELEASED
R 2010-04-14
M

B	80° WAS 83°, 0.33 WAS 0.55 & 2.10 WAS 2.50 (ZN C6-2)	RF	10.03.19
A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MM</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>MM</i>	D4049	SHEET 1 OF 7
APPROVED	<i>MM</i>	TITLE	SCALE
DE APPR.	<i>MM</i>	MOUNTING LUG ASSY	NTS
DATE	10.03.19	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OTHER THAN CONSIDERED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

A

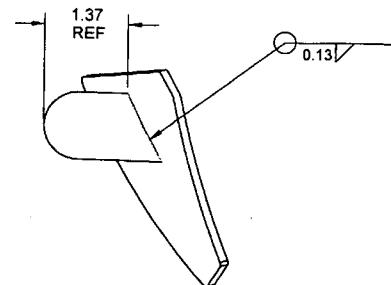
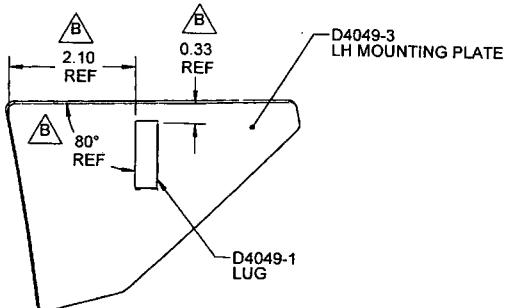
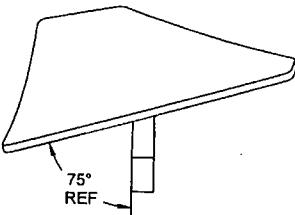
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/058073

8 D4049-041 MOUNTING LUG ASSY, LH

NOTES.

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DT9584

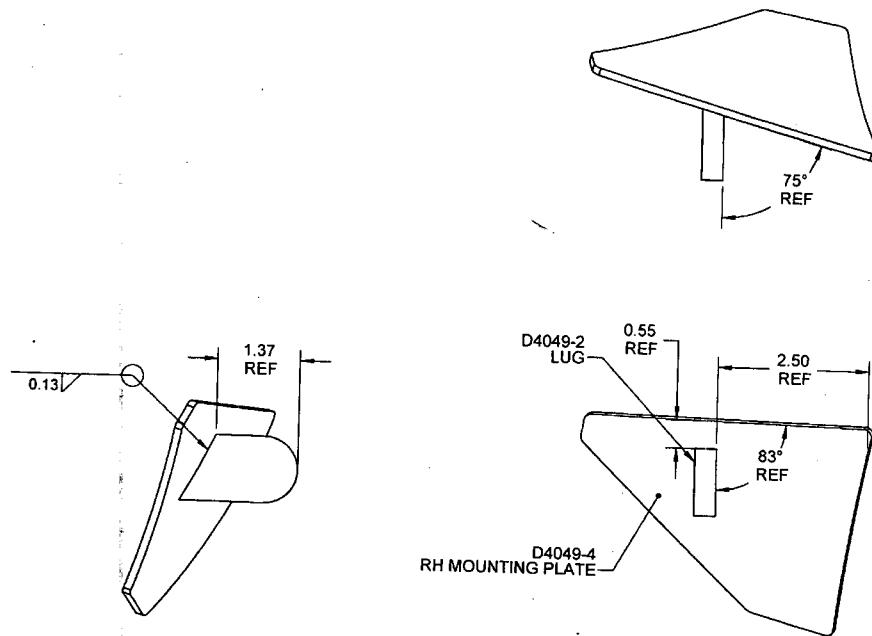
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DRAWN	RF			
CHECKED	RF	DRAWING NO.	REV. B	
MFG. APPR.	RF	D4049	SHEET 2 OF 7	
APPROVED	RF	TITLE	SCALE	
DE APPR.	RF	Mounting Lug Assy		
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



8 D4049-042 MOUNTING LUG ASSY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DT9583

RELEASED
2010-04-14
NP

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MM	DRAWING NO.	REV. B
MFG. APPR.	DS	D4049	SHEET 3 OF 7
APPROVED	MM	TITLE	
DE APPR.	MM	SCALE	
DATE	10.03.19	NTS	

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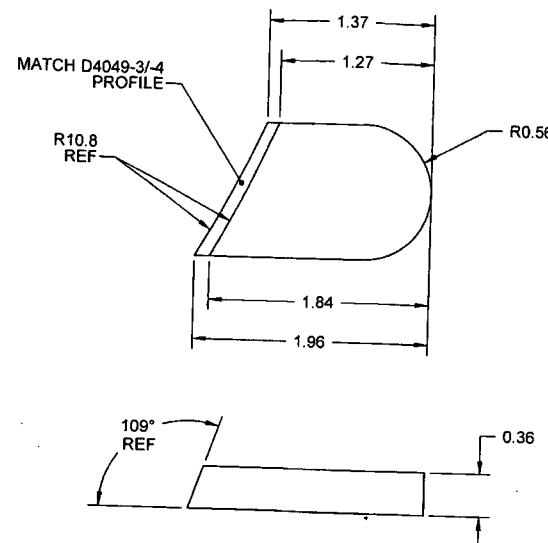
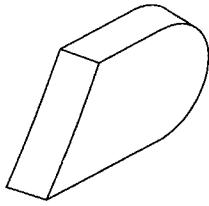
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D4049-1 LUG (SHOWN)
D4049-2 LUG (OPPOSITE)

wlo 58023

RELEASED
2010-04-14
NM

NOTES:

- 1) MATERIAL: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs

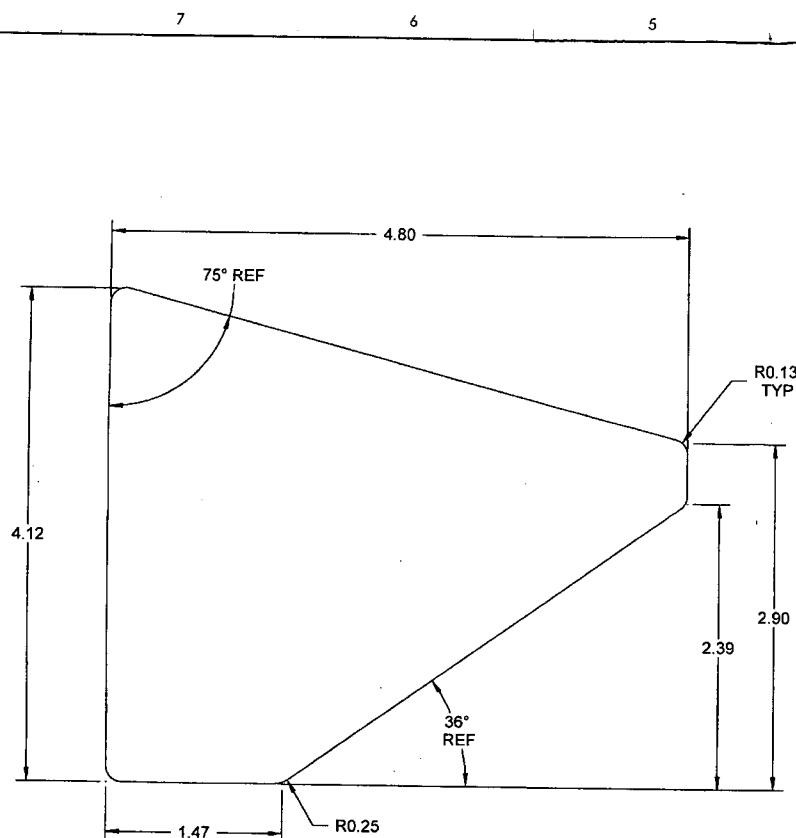
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	#	D4049	SHEET 4 OF 7
APPROVED	#	TITLE	SCALE
DE APPR.	#	MOUNTING LUG ASSY	NTS
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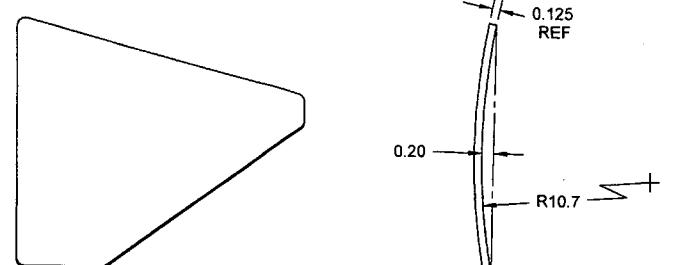
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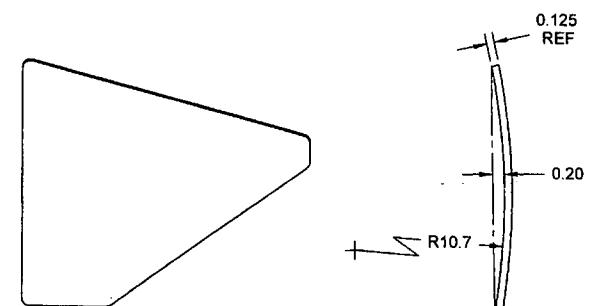
D4049-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH, 0.125" THICK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.46 lbs



D4049-3 MOUNTING PLATE, LH
(MAKE FROM D4049-3F FLAT PATTERN)



D4049-4 MOUNTING PLATE, RH
(MAKE FROM D4049-3F FLAT PATTERN)

W/068073
RELEASED
2010-04-14

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	<input checked="" type="checkbox"/>	
MFG. APPR.	<input checked="" type="checkbox"/>	
APPROVED	<input checked="" type="checkbox"/>	
DE APPR.	<input checked="" type="checkbox"/>	
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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

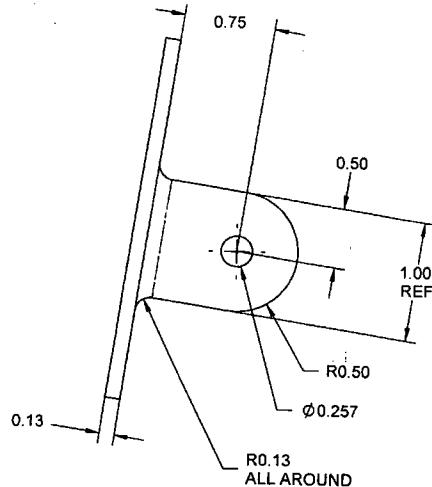
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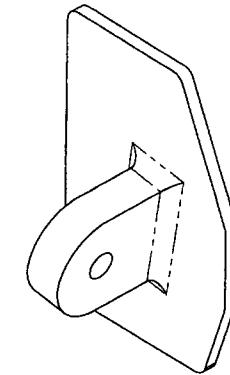
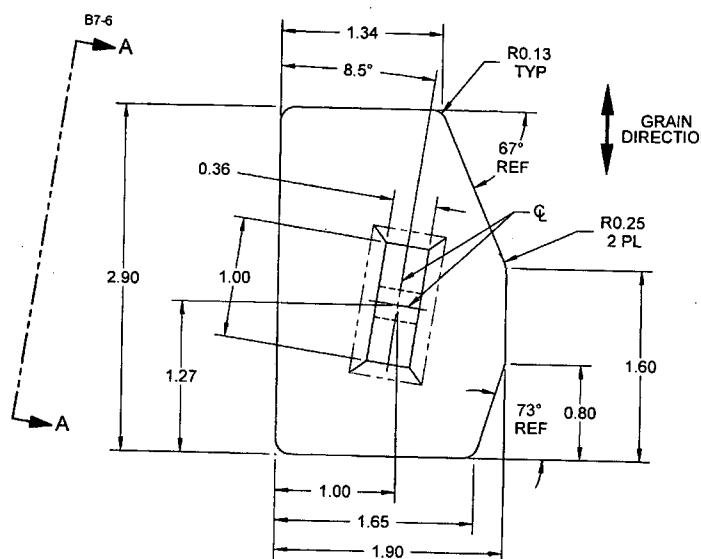
C

B

A



VIEW A-A D5-6



W058023

RELEASED
2010-04-14
ND4049-5 MOUNTING LUG, LH

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AMS-QQ-A-225/8 OR AMS-QQ-A-200/8 OR ASTM B211 OR B221
PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs

8 7 6 5 4 3 2 1

DESIGN DRAWN	RF RF	DART AEROSPACE LTD	
CHECKED	RF	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	RF	DRAWING NO.	REV. B
APPROVED	RF	D4049	SHEET 6 OF 7
DE APPR.	RF	TITLE	SCALE
		MOUNTING LUG ASSY	NTS
DATE	10.03.19		

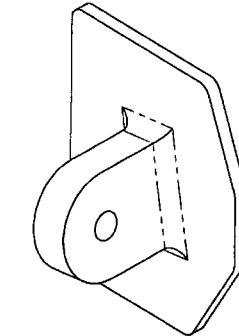
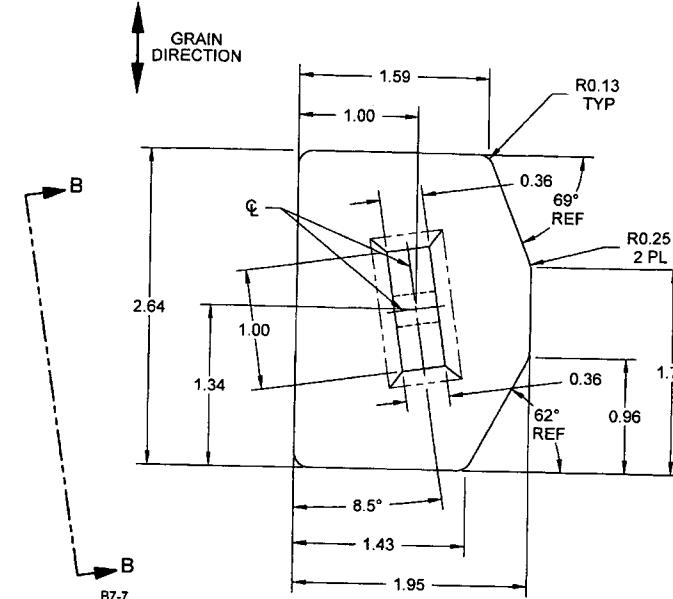
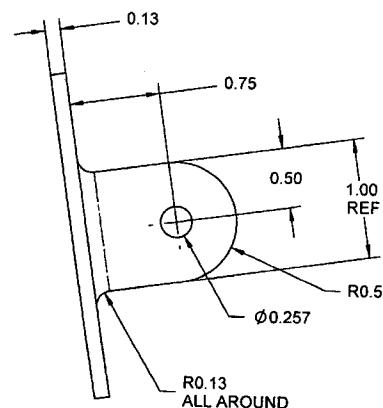
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



VIEW B-B B5-7

D4049-8 MOUNTING LUG, RH

NOTES:

1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AMS-QQ-A-225/8 OR AMS-QQ-A-200/8 OR ASTM B211 OR B221
PER DART SPEC M6061T6B

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-8" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 0.10 lbs

RELEASED
2010-04-14

DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	RF	DRAWING NO.	REV. E	
MFG. APPR.	RF	D4049	SHEET 7 OF	
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DE APPR.	RF	MOUNTING LUG ASSY NTS		
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